

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021800**Date Inspected:** 08-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14 East

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Zhong Yong Gang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SA-3013-001

Weld No: 003

Welder: 051356

WPS-B-T-2233-ESAB

PCMK: SEG-3007N

Weld No: 261

Welder: 055564

WPS-B-T-2233-ESAB

PCMK: SEG-3007G

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## WELDING INSPECTION REPORT

( Continued Page 2 of 4 )

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Weld No: 013  
Welder: 055491  
WPS-B-T-2233-ESAB

PCMK: SEG-3007J  
Weld No: 011  
Welder: 050242  
WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.  
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.  
ZPMC QC is identified as Zhong Yong Gang.  
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).  
Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3019AW  
Weld No: 041 and 042  
Welder: 050696  
WPS-B-P-2212-B-U2-FCM-1

PCMK: SEG-3019T  
Weld No: 117 and 146  
Welder: 050969  
WPS-B-P-2212-B-U2-FCM-1

PCMK: SEG-3019U  
Weld No: 003  
CWR: 2822  
Welder: 215553 and 216086  
WPS-345-SMAW-2G(2F)-FCM-1

PCMK: SEG-3019K  
Weld No: 16~19  
WR: 20357  
Welder: 044779  
WPS--345-SMAW-4G(4F)-FCM-1

PCMK: SEG-3019K  
Weld No: 22, 24, 26, and 28  
WR: 20357  
Welder: 056013  
WPS--345-SMAW-4G(4F)-FCM-1

PCMK: DP-3097-001

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## WELDING INSPECTION REPORT

( Continued Page 3 of 4 )

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Weld No: 017, 032, 047, 062 and 077

Welder: 037748

WPS-B-P-2113-TC-U4b-FCM-1

Bay 16

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Peng Wen Jun.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: BP-3050-001

Weld No: 041, 042, 049, 044 and 050

Welder: 053753

WPS--345-SMAW-2G(2F)-FCM-1

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Ma Qian Li.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: E5-SB25-004

Weld No: 032, 033, 036 and 037

Welder: 048625

WPS-B-T-2132-ESAB

PCMK: W5-SB38-001

Weld No: 058~061

Welder: 062092

WPS-B-T-2132-ESAB

PCMK: W2-SB23-001

Weld No: 027~030

Welder: 222396

WPS-B-T-2132-ESAB

PCMK: E5-SB25A-002

Weld No: 013, 014, 017, 018, 021 and 022

Welder: 201074

WPS-B-T-2231-ESAB

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

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## WELDING INSPECTION REPORT

( Continued Page 4 of 4 )

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ZPMC was using the Heat Straightening process.

ZPMC QC is identified as Ma Qian Li.

Welding variables recorded by QC appeared to comply with the approved Heat Straightening Procedure Specification (HSR). Listed below are the locations that were identified by this QA inspector.

PCMK: BK-004A-013

HSR-1(B)-9501

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

No relevant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Rice,Brett	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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